

# Work Order ID 54761

December 21, 2009 9:05:47 AM



Page 1

Item ID: D3121-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 12/21/09 Start Qty: 8.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



BAND SAW

*M.A 09/12/30*

*8*

*φ*

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 2.000") 4.425" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

*M.A 10/01/03*

*8*

*φ*

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3121-113 as per Folio FA330 and Dwg D3121  
Identify as D3121-113  
2-Deburr  
3-Scribe batch number

120

0.00



QC2- Inspect parts off machine FAI/FAIB

*M.A 10/01/03*

*8*

*φ*

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54761**

December 21, 2009 9:05:47 AM



Page 2

Item ID: D3121-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 12/21/09 Start Qty: 8.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

10-01-05

8

8

140



Small Fab

Small Fab

Small Fab

Memo

Assemble D3121-143 as per Dwg D3121.

0.00

0.00

10/01/05 (8)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

(x8)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 54761**

December 21, 2009 9:05:48 AM



Page 3

Item ID: D3121-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 12/21/09 Start Qty: 8.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

Identify as per dwg & Stock Location: 235A

0.00



Packaging

Memo

0.00

Packaging

P 10/01/06 (8)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06 MF

MF

10-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

December 21, 2009 9:05:46 AM

Page 1

Work Order ID: 54761

Parent Item: D3121-143

Parent Item Name: Bracket Assembly


Comments:

Start Date: 12/21/09

Required Date: 1/04/10

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M174B1.250X02.000		Purchased	No			100	f	25.7389	3.0989			
												
17-4 SS Bar 1.250 x 2.00												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

25.73894736

109851

0.73894736

113437

25

D3121-21

Manufactured

No

140

Each

43.0000

16.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

46032

5

50096

10

52518

28

D3121-241

Manufactured

No

140

Each

31.0000

16.0000



Bearing Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

31

52592

31

2.9866 ft M.A 09/12/30

EP 10/01/05

B54769 (142)

2

EP 10/01/05

B54770 (7x)

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 54761
<b>Description: Bracket</b>		<b>Part Number:</b> D3121-113
<b>Inspection Dwg:</b> D3121	<b>Rev:</b> E	<b>Page 1 of 2</b>

### FIRST ARTICLE INSPECTION CHECKLIST

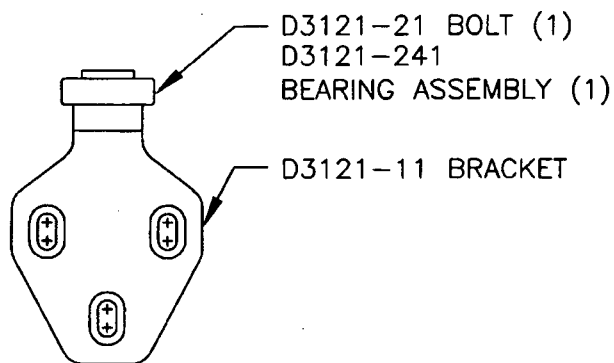
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.300	✓			
R0.375	+/-0.010	R0.375	✓			
1.54	+/-0.030	1.540	✓			
0.350	+/-0.010	0.350	✓			
R0.25	+/-0.030	R0.250	✓			
Ø0.392	+0.002/-0.000	Ø0.3935	✓			
Ø0.201	+0.005/-0.000	Ø0.202	✓			
2.540	+/-0.010	2.540	✓			
1.590	+/-0.010	1.590	✓			
0.160	+/-0.010	0.160	✓			
0.400	+/-0.010	0.400	✓			
1.220	+/-0.010	1.222	✓			
1.600	+/-0.010	1.602	✓			
3.80	+/-0.030	3.800	✓			
1.800	+/-0.010	1.802	✓			
R0.50	+/-0.030	R0.500	✓			
0.130	+/-0.010	0.132	✓			
3.41	+/-0.030	3.390	✓			
3.65	+/-0.030	3.635	✓			
2.24	+/-0.030	2.210	✓			
45°	+/-0.1°	45°	✓			
R0.25	+/-0.030	R0.25	✓			
3.97	+/-0.030	3.971	✓			
R0.38	+/-0.030	R0.380	✓			
Ø0.392	+0.002/-0.000	Ø0.3935	✓			
Ø0.201	+0.005/-0.000	Ø0.202	✓			
0.268	+/-0.010	0.265	✓			
R0.260	+/-0.010	R0.260	✓			
0.080	+/-0.010	0.080	✓			
0.300	+/-0.010	0.300	✓			
0.381	+/-0.010	0.382	✓			
0.201	+/-0.010	0.203	✓			
0.580	+/-0.010	0.582	✓			

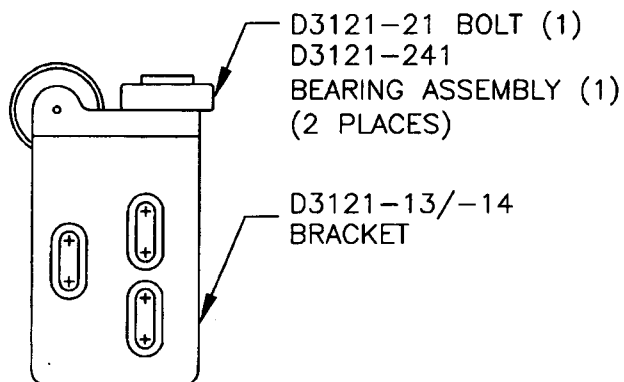


**DART**

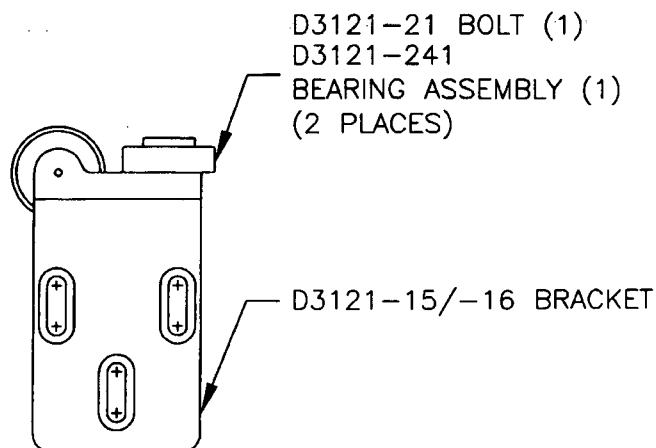
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 1 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2
A	02.04.15	NEW ISSUE	
B	03.01.16	ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146	
C	04.02.17	ADD CLEARANCE; USE -241 BEARING	
D	06.05.17	D3121-25 CAP WAS 1.024, NOW 1.000	
E	07.11.07	ADD TOLERANCE TO 0.032 (DETAIL B)	

**RELEASED**  
07.11.07

**D3121-041 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-33)

*W/O SUPPLY*

**D3121-043 (SHOWN) / D3121-044 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-37/-38)



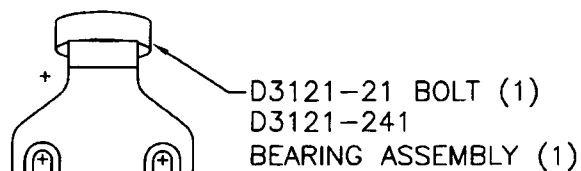
**D3121-045 (SHOWN) / D3121-046 (OPPOSITE)  
BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-35/-36)

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CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 2 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

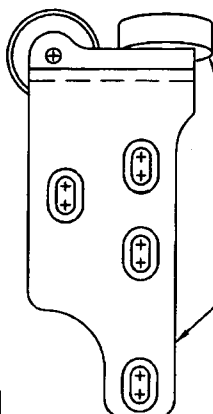


D3121-111 BRACKET

**D3121-141 BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23001-01)

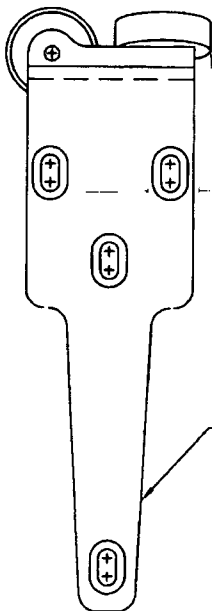
RELEASED  
07.11.07

WLB  
54761



D3121-113/-114 BRACKET

**D3121-143 (SHOWN) / D3121-144 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-03/-04)

D3121-115/-116  
BRACKET

**D3121-145 (SHOWN) / D3121-146 (OPPOSITE)**  
**BRACKET ASSEMBLY**  
(REPLACES PREMIER P/N B30-23000-05/-06)

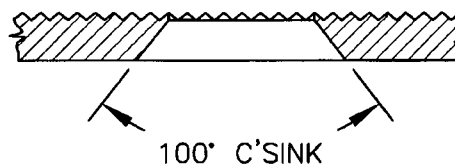
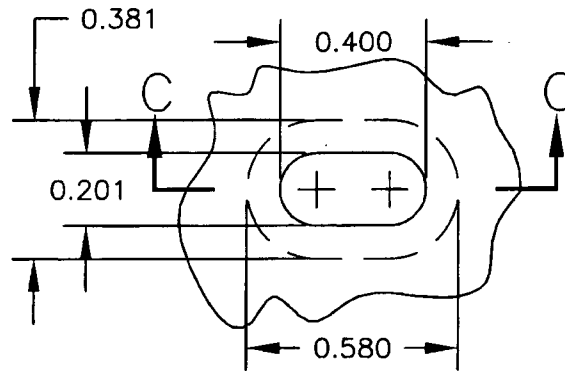
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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

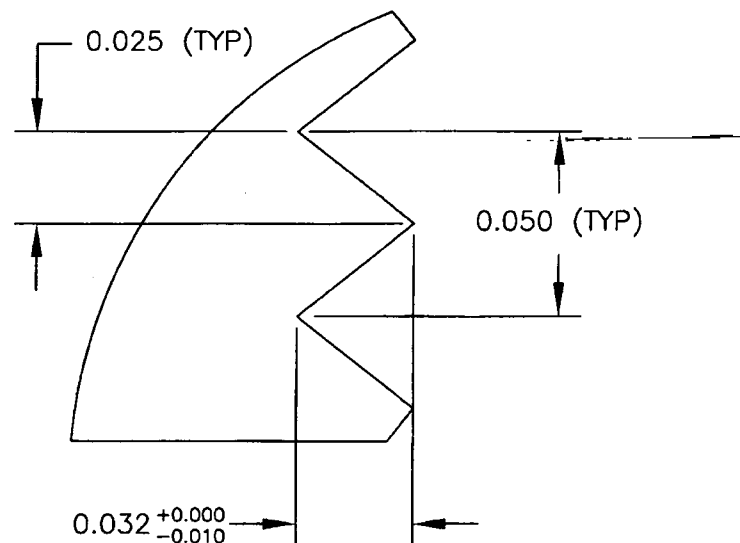
**DETAIL A:  
SLOT DETAIL**  
SCALE 2:1  
VIEW ROTATED



**SECTION  
C-C**

**RELEASED**  
07.11.07

**DETAIL B:  
RIDGE DETAIL**  
PARTIAL SECTION  
SCALE 1:20

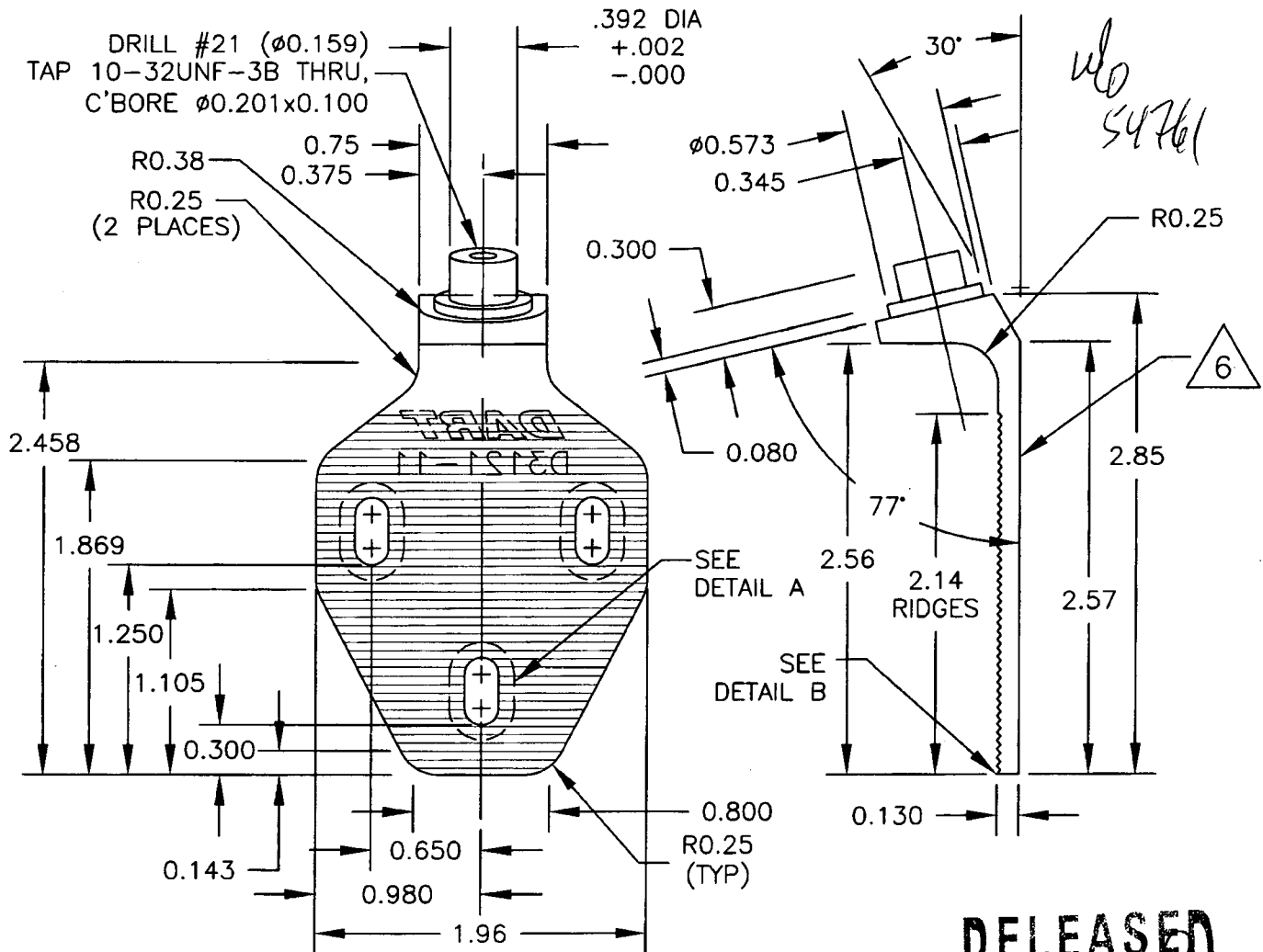


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**DART**

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 4 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**RELEASED**  
07.11.07**D3121-11 BRACKET**

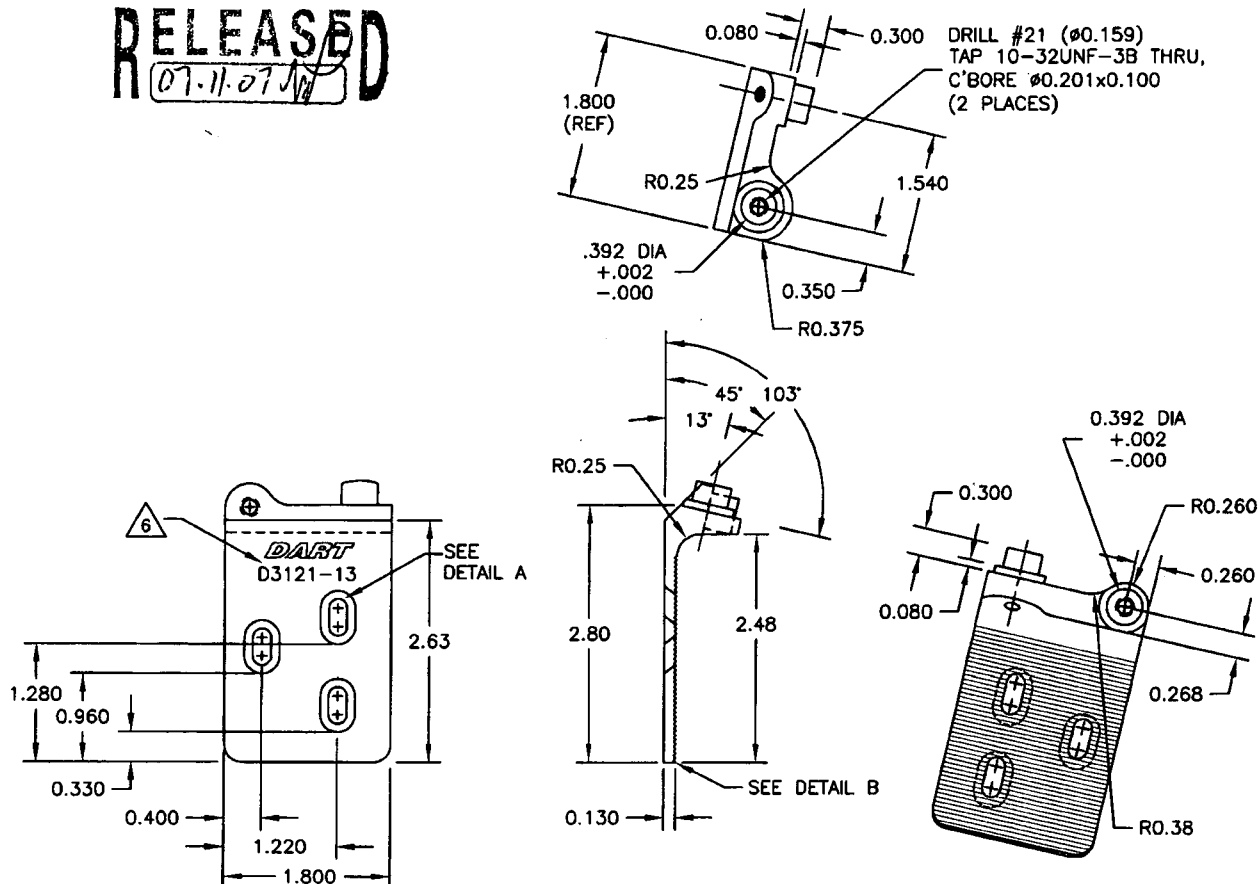
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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**DART**

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 5 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07**D3121-13 BRACKET (SHOWN)****D3121-14 BRACKET (OPPOSITE)**

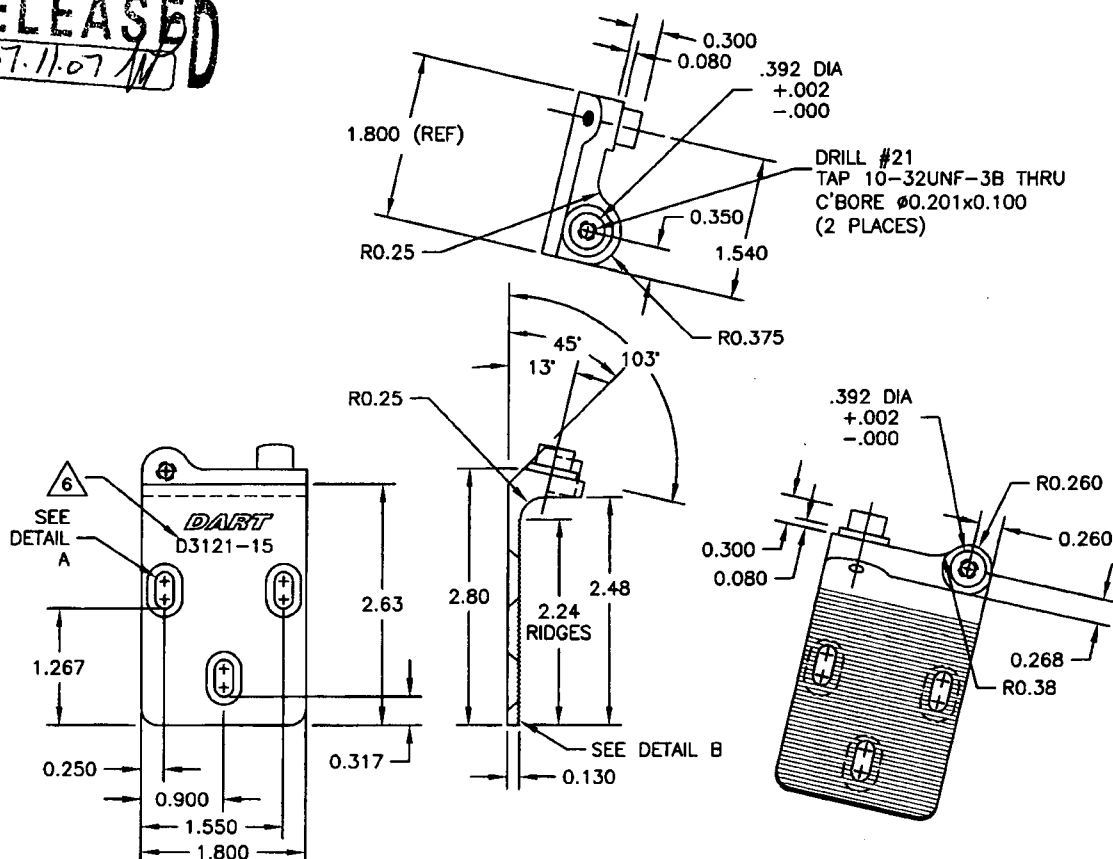
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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**DART**

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 6 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07*WLO 54761***D3121-15 BRACKET (SHOWN)****D3121-16 BRACKET (OPPOSITE)**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

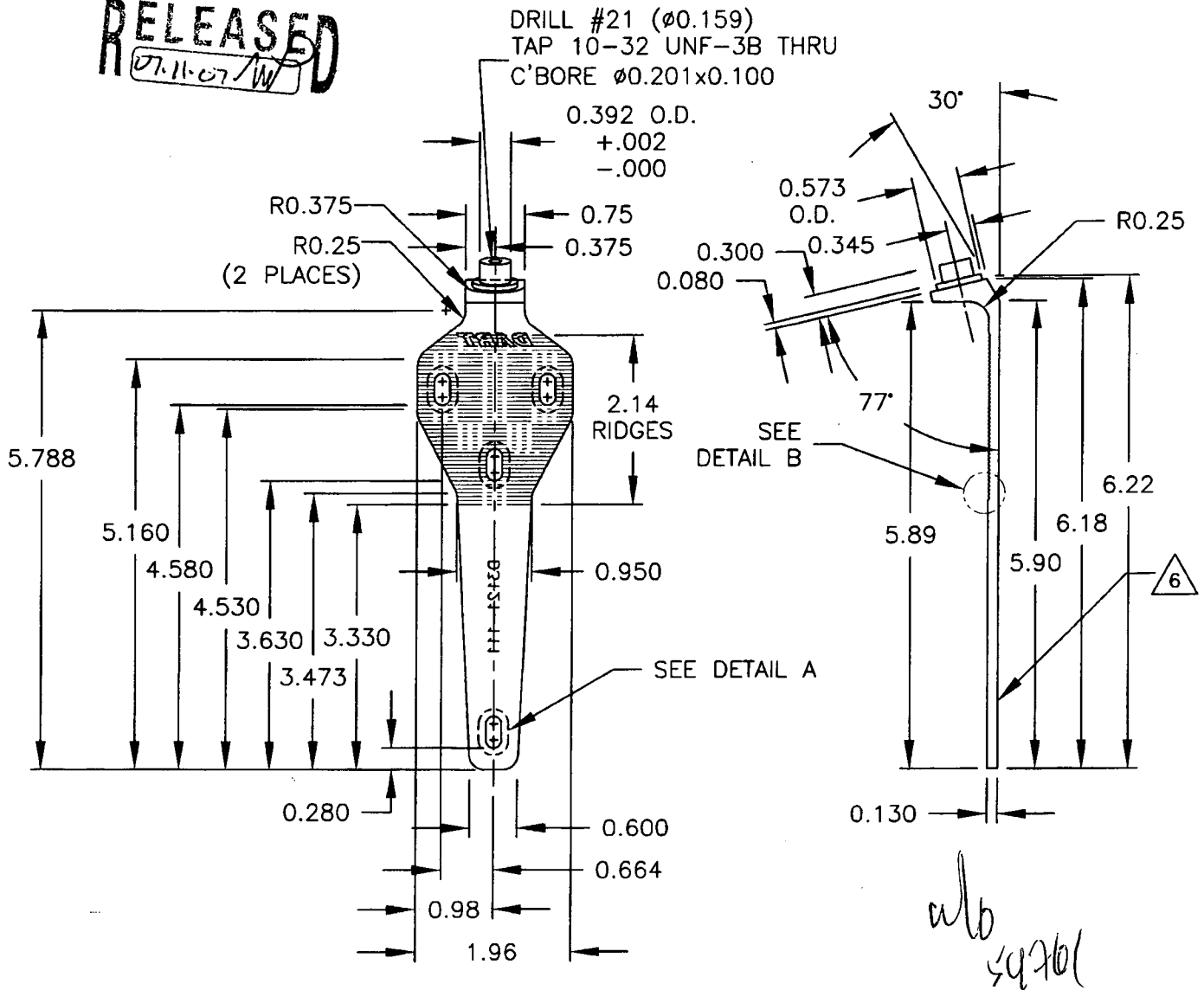
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**DART**

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07/W**D3121-111 BRACKET**

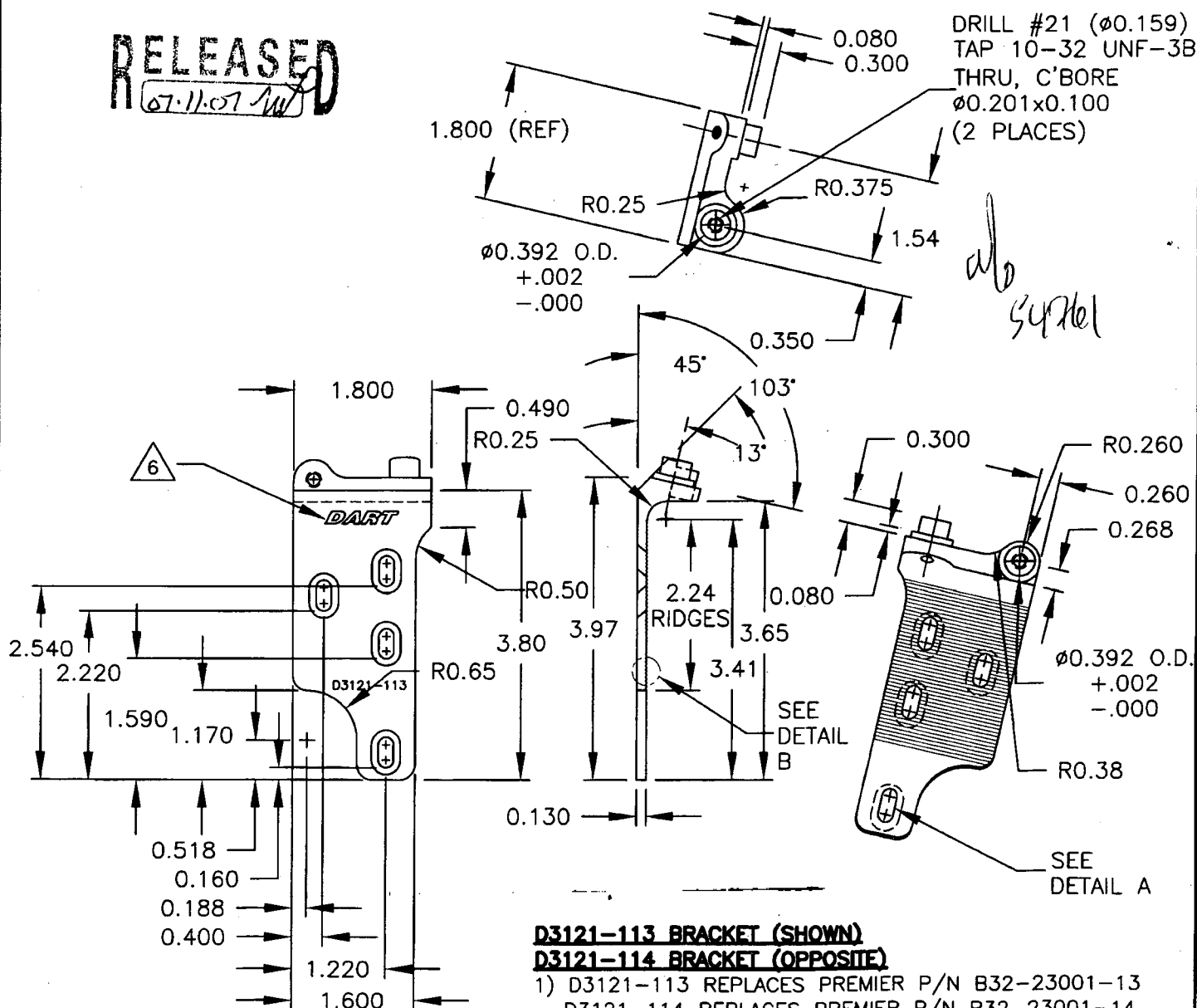
- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE = 150 ksi  
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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**DART**

DESIGN #	DRAWN BY LE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 8 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

**RELEASED**  
07.11.07

**D3121-113 BRACKET (SHOWN)**  
**D3121-114 BRACKET (OPPOSITE)**

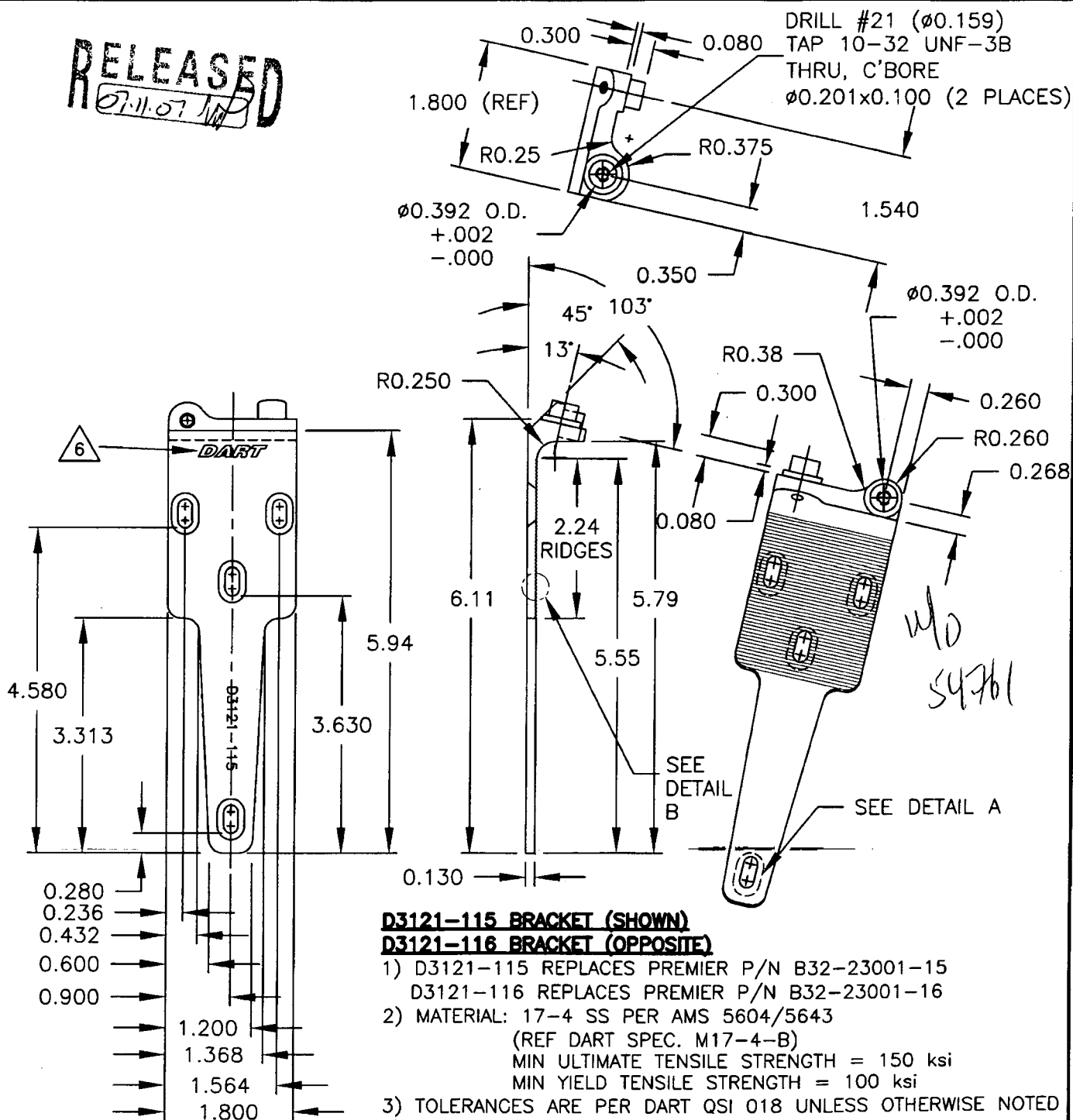
- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13  
D3121-114 REPLACES PREMIER P/N B32-23001-14
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 9 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:2

RELEASED  
07-11-07



**D3121-115 BRACKET (SHOWN)**  
**D3121-116 BRACKET (OPPOSITE)**

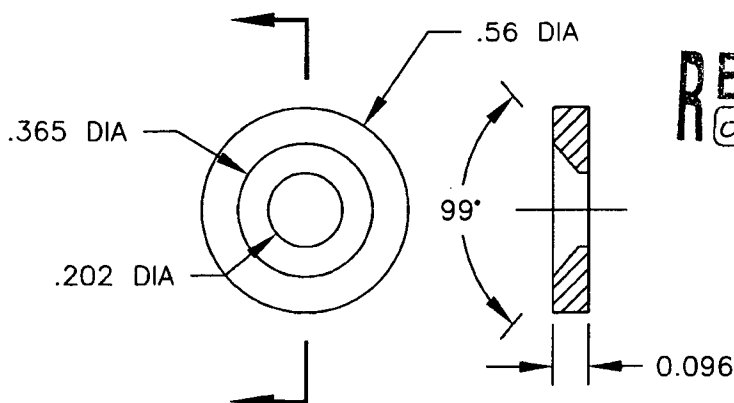
- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15  
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643  
(REF DART SPEC. M17-4-B)  
MIN ULTIMATE TENSILE STRENGTH = 150 ksi  
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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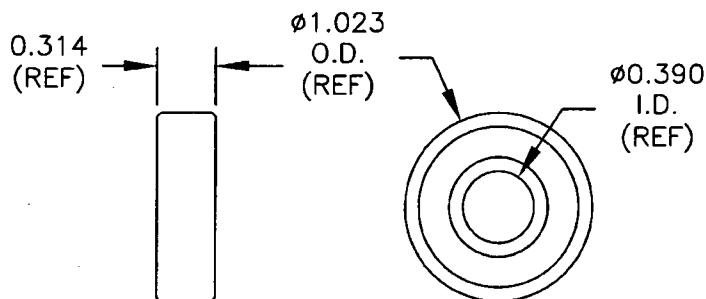
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**DART**

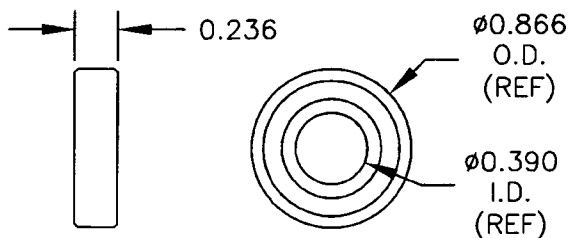
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

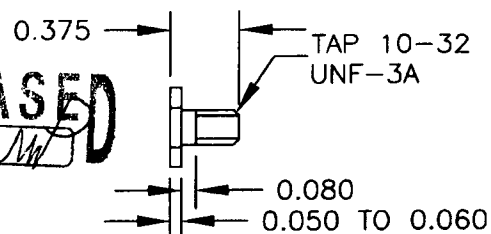
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

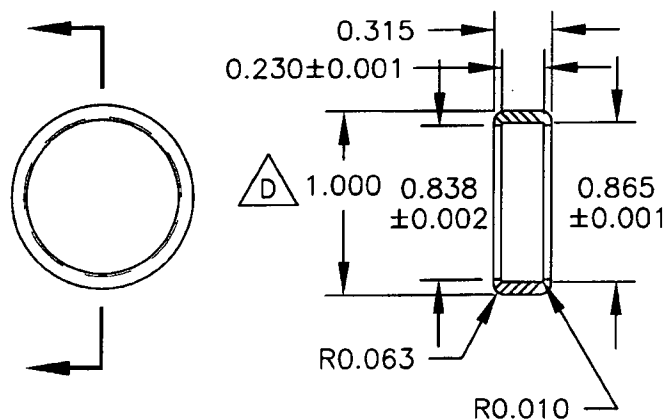
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM, FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

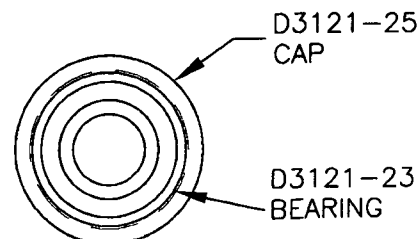
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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